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RB877528-4
Job Sheet 197574



Part No: RB877528-4

Job Qty: 1 pcs

Part Name: Pitchlink Bearing Cutter



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/10/19

Job Tracking No:

Due Date: 8/26/19

Created By: Marie Lajeunesse

Type: SOLD

Description: ORDER 17841

Note: DWG RB877528-4 REV 3 IPP REV:A 17.07.21 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	8/26/19	0.00	0.08	Small Fab - 1		MLC	
						Small Fab - 2			
						Small Fab - 3			
						Small Fab - 4			
						Small Fab - 5			
						Small Fab - 6			
						Small Fab - 7			
120	QC 4-5	1 pcs	8/26/19	0.00	0.00	QC 4 - 28			
						QC 4 - 58			
						QC 4 - 69			
						QC 4 - 9			
						QC 4 - 46			
						QC 4 - 68			
						QC 4 - 72			
Packag 3-6 -					QC 5	QC 4 - 74		DAS 40 9-89	
						QC 4 - 75			
						QC 21 - SA - 21			
						QC 21 - SA - 70			
140	QC 21 - SA	1 pcs	8/26/19	0.00	0.00	QC 21 - SA - 53		DAS 28 9-89	

Part Op 110 - 1-Pick kit 2-Bag and tag
Descriptions: 120 - (QC4- 100% Inspect kits for completeness)
140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB877528-16	Remove & Install Tool	1 pcs (1 ea)	110-Small Fab - 1	5045323
RB877528-4-2	Cutter Assembly	1 pcs (1 ea)	110-Small Fab - 1	519198

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	RB877528-4-16	1	1	0
	RB877528-4-2	1	0	0
Part Specifications				
Specifications could not be found.				

Plex 7/10/19 1:55 PM Dart.lajeunesse.marie



Container No: S198808



Part: RB877528-4

Job No: 197574

Serial No/Batch: S198808

Revision: 3

Inspector:

Exp Date:

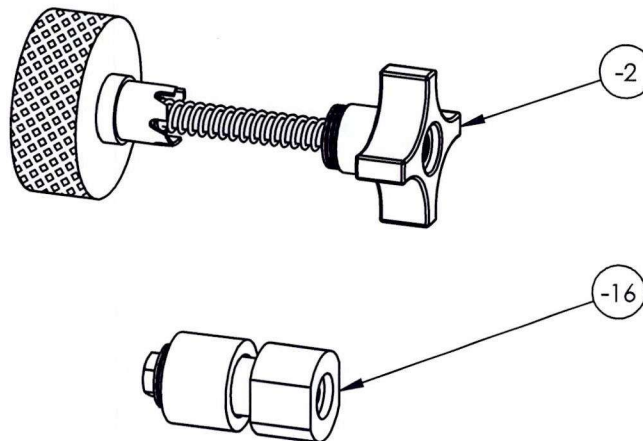
Instructions:

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Date: 07/18/19

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-7 RADIAL ANGLE INCREASED FROM 2° TO 5° TO IMPROVE OPERATION.	2/19/2004	-	-
2		CH'D NOTE P/N -7 TURN TO FROM .660 PER GABRIEL. CH'D REVISIONS TO NUMERICAL. CH'D TITLEBLOCK & REVISION BLOCK, MADE SECTION VIEW A-A P/N -6, LABELED SECTIONS B-B P/N -17, & SECTION C-C P/N -21.	7/27/2009	RJC	-
3	15-0104	UPDATED TO NEW DRAFTING STANDARDS. -1 CH'D DIM WAS Ø.501 IS Ø.5012-.5016. ADDED DIM .10. DELETED TAPER. DELETED DIM 2.000. ADDED DIM 2.50. ADDED MIN. RELIEF. -10 CH'D B/O INFO WAS EUGENE FASTENER #16 IS MCMASTER-CARR #9657K122. -11 ADDED QTY 2 TO -16 ASSY. -13 ADDED QTY 1 TO -16 ASSY. -17 DELETED DIMS .493, .420. ADDED DIM 43.6°. CORRECTED TYPO ON THREAD CALLOUT. -19 ADDED B/O INFO #97633A130. -23 & -25 DELETED. -27 CH'D DIM WAS .030 IS .030 +.005 -.000. ADDED B/O INFO #91247A014. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	5/13/2015	DPD	JAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 197574 MJS
19-07-10

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	P.G.
	1		-1		SHAFT	STRESSPROOF		2
	X		-2	1	CUTTER ASSEMBLY			3
	1		-3		HANDLE	6061 T6		4
	1		-7		6 TOOTH CUTTER	0-1		5
	1	B/O	-10		SPRING	STEEL	Ø.437 OD X Ø.054 WIRE X 2, 15.54 LBS./IN. (MCMASTER-CARR #9657K122)	3
2	2	B/O	-11		WASHER	STEEL	TRA-411 (APPLIED INDUSTRIAL)	3 & 6
1	1	B/O	-13		BEARING	Alloy Steel	NTA-411 (APPLIED INDUSTRIAL)	3 & 6
	1	B/O	-15		KNOB		1/4-20 (ESSENTIA COMPONENTS #DK-54)	3
X			-16	1	REMOVE & INSTALL TOOL			6
1			-17		R & I ADAPTER	STRESSPROOF		7
1		B/O	-19		SNAP RING	STEEL	Ø1/4 (MCMASTER-CARR #97633A130)	6
1			-21		CAP	6061 T6		8
1			-27		BOLT	STEEL	1/4-28 X 1-3/4 (MCMASTER-CARR #91247A014) MODIFIED	9
ASSY -16	ASSY -2							

		TITLE	
		DAMPER BEARING TOOL KIT	
DWG NO.		REV	
RB877528-4		3	
MATERIAL		DRAWN BY: PERRITT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED <i>D Weik</i>	
.XXX ± .005 FRACTIONS ± 1/8		HEAT TREAT	
.XX ± .01 ANGLES ± 5°		FINISH	
.X ± .1		SPEC	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		USED ON MODEL	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		MD 500D	
SCALE 1:2	DATE 6/28/2000	SHEET 1 OF 9	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details:			